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If no title is shown please refer to the description.
Si aucun titre n'est indiqué se référer à la description.)

Method for modelling life of a piece of equipment in a industrial plant, method
for performing maintenance on an industrial plant and maintenance-system

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"Method for modelling life of a piece of equipment in an industrial plant,
method for performing maintenance on an industrial plant and maintenance-
system"

This invention relates to a method for modelling life of a piece of equipment in a furnace. More particularly, the invention relates to a method for modelling coil life in a furnace.

- 5 Coils in furnaces are known to fail after a time of usage, wherein coil failure is defined as a coil crack or a rupture. Since the end of the coil life caused by the failure as a rule does not coincide with the end of the desired use of the furnace, the coil needs to be replaced in order to further use the furnace. Especially in large chemical plants coils of considerable size are used that
- 10 are very expensive. On the other hand, every day of non-operation of a furnace caused by replacement of the coil and/or waiting for a newly ordered coil to arrive is also a great loss of potential yield. Operators of furnaces are thus confronted with the question of when to buy a new coil, whether to keep this coil as a spare and when to replace the coil in use with the newly bought
- 15 one. Costs could be minimized, if the exact date of coil failure could be determined. Since coil life is dependent on a multitude of influencing-

parameters, most of which even vary during the coil life, such as feed rate of material fed into the furnace to be heated, a way of determining the exact date of coil failure has not yet been found. For this reason statistical methods are used to predict an expected coil life.

5

One statistical method used is the so-called Weibull analysis, which on some items generates a characteristic bathtub failure curve. This failure curve can be used to determine the probability of the item failing over time, giving operators an indication on when the item failure is to be expected with great probability. Because of the many failure modes possible for a coil in a furnace, the Weibull analysis has been found to be limited in its use for coil life modelling.

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These problems also arise when modelling the life of other pieces of equipment in the furnace. Here also, no reliable way has been found to model the life of this piece of equipment.

15

It is thus an object of the current invention to provide a method for modelling life of a piece of equipment in an industrial plant, especially in a furnace, which provides a better prediction for an expected life. Furthermore it is an object of the current invention to provide a method for performing maintenance on an industrial plant and a maintenance-system which allow considerable cost reductions for operating the industrial plant.

20

These objects are solved by the methods and the maintenance system as defined in the independent claims. Further embodiments are defined in the dependent claims.

25

The inventors have realized that the influence of each of the multitude of influencing-parameters relevant for the life of a piece of equipment of an industrial plant thus, can best be found by use of multiple regression analysis. Thus a model for coil life that expresses an expected life in terms of variables relevant for the life is best found by use of an multiple regression analysis.

Multiple regression analysis is a known statistical method and shall thus not be described in detail. It is used to generate a formula of the type

$$Y = b_0 + b_1X_1 + b_2X_2 + \dots + b_kX_k + E \quad (1)$$

Where Y = value to be predicted

b_0 to b_k = constants

X_1 to X_n = any of all variables or functions of a few basic variables

k = maximum number of constants

E = the unexplained error.

The constants are found by the multiple regression analysis using data from already completed processes. The equation thus relates the desired value to predict directly to the variables.

Using multiple regression analysis gives the advantage of providing an equation that can take a multitude of influencing-parameters into account. The desired value to predict is thus not determined solely in its dependency on a single influencing-parameter, which has proved to be inadequate, but on many influencing-parameters. Thus the different influences parameters have on the life of a piece of equipment, such as prolongation or shortening, can all be accounted for, giving a better prediction of the life to be expected.

Advantageously the influencing-parameters that are put into the equation are pre-selected according to their correlation and their significance. Some influencing parameters or terms can correlate among each other (exact, singular
5 or multiple linear), making the prediction model unstable, over-fitted and over-sensitive. Small random changes in data can thus cause huge unrealistic predictions. This is because the variables are not occupying all directions of the regression space. Also influencing-parameters can be non-significant. Their inclusion can give false indication of the goodness of the fit, give higher
10 variance in the equation coefficients and increase variance in the predictions itself. Thus, using all possible influencing-parameters in a search for the best prediction possible leads to a bad or worthless prediction and is thus advantageously not performed.

15 Trying every combination of the influencing parameters available in the database in order to identify the combination that leads to a model with the best performance is a very time consuming process and needs very powerful hardware to be undertaken. Thus it is advantageous in order to reduce the equipment necessary for the modelling-method according to the invention to
20 only try equations based on certain, selected combinations of variables in order to find the best model.

A first step for selecting the variable combination is obtaining information on the correlation the individual values for a single variable in the database
25 have among each other and obtaining information on the significance of the variables on the value to be predicted. This is done by determining significance values and correlation values. Advantageously, as significance value the Prob>F value is used. The lower this value is, the more significant the influencing-parameter is. Also preferred, as correlation value the VIF-value is

used. The lower the VIF value, the lower the correlation of the influencing-parameter in comparison to the other influencing-parameters. According to a special embodiment of the invention, these Prob>F values and VIF values are obtained from all influencing-parameters in their relation to the influencing-parameters that are already used in a tried equation. This helps determining, which influencing-parameter is introduced into the equation as next influencing-parameter. According to the invention, of the parameters not yet introduced into the equation, the parameter that has the lowest significance value (Prob>F), ie. the influencing-parameter that has the highest significance, and at the same time has the lowest correlation value (VIF), ie. the influencing-parameter with the lowest correlation to the parameters already in the equation (equation-parameters) is used.

At the same time, the inventors have realised, that only introducing the influencing-parameter, which at each step of generating the equation shows the lowest absolute values for the significance value and the correlation value does not necessarily lead to the best model. Accordingly, the inventors have created a way of successively introducing and excluding influencing-parameters from the equation to be generated on the basis of predetermined rules.

The multiple regression analysis, that is part of the method for modelling the life of a piece of equipment, the method for performing maintenance and is used in the maintenance-system according to the invention, uses the following steps:

- a) determining a start value as first influencing-parameter,
- b) generating a current equation based on the start value and thereby enter-

ing the start value as equation-parameter into the equation,

c) determining a significance value and a correlation value for each influencing-parameter with respect to the equation-parameter(s),

5

d) selecting as new equation-parameter the influencing-parameter with the highest significance and the lowest correlation that is not an equation-parameter and has according to a parameter-database not been used as equation-parameter in combination with the equation-parameters of the current equation,

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e) replacing the current equation with a new current equation by generating the new current equation based on the equation-parameters now including the new equation-parameter by means of multiple regression analysis based on the values of the value-database,

15

f) recording in parameter-database the combination of influencing-parameters already used as equation-parameters and the order of introducing the equation-parameters into the current equation,

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g) calculating the performance of the current equation and recording this performance with reference to the equation-parameters in the current equation in a performance-database

25 h) repeating the steps c) to g) until for none of the influencing-parameters that are not equation-parameters the significance is higher than a predetermined value while at the same time the correlation is lower than a predetermined value or either the significance of an equation-parameter has become lower than a predetermined value or the correlation of an equation-parameter

ter becomes higher than a predetermined value,

5 i) excluding the influencing-parameter that according to the parameter-database was last selected as new equation-parameter and replacing the current equation with a new current equation by generating the new current equation based on the equation-parameters that remain after exclusion of the last selected influencing-parameter by means of multiple regression analysis based on the values of the value-database,

10 j) repeating the steps c) to i) until the influencing-parameter to be excluded is the start value,

15 k) selecting from the database the set of equation-parameters which provided the best performance and generating a final equation by use of multiple regression analysis based on these influencing-parameters and their individual values in the value-database.

20 Advantageously, the start value used is the intercept, ie. the mean of the values available in the database for the parameter to be modelled. The equation that uses the intercept as influencing-parameter that is introduced as equation-parameter is the most basic way of modelling life of a piece of equipment in an industrial plant, ie. setting the expected life to be equal the mean of all the life-spans that are recorded in the database.

25 The significance and the correlation of the available influencing parameters is advantageously determined using the Prob>F value and the VIF value, whereby a low Prob>F value shows a high significance and a low VIF value a low correlation.

In order to improve the most simple equation, this method relies upon introducing further (new) influencing-parameters as equation-parameters into the equation. However, the way of selecting new equation-parameters is made dependent on rules that prevent redundancies in calculation and unnecessary calculations, thereby advantageously reducing the calculation time necessary.

According to the first rule, no influencing-parameter is selected as new equation parameter that is already a equation parameter of the equation in its current form. Furthermore no influencing-parameter is used that has already been made basis for a previously sampled equation in combination with the equation parameters currently in the equation. This prevents redundancies that occur, when - for example - it is considered to introduce of a numbered list of influencing-parameters the third influencing-parameter into an equation that is based on the first influencing-parameter and where a combination of the third influencing-parameter and the first influencing-parameter as equation-parameters has already been sampled. In this case the third influencing-parameter would not be selected, as it would not lead to a new combination.

According to a second rule, no influencing-parameter is selected, which is insignificant and/or correlated to the equation-parameters already in the equation relative to predetermined rules. These could be that no influencing-parameter is introduced that has a Prob>F value larger than 0,05 and a VIF-value of more than 5. These predetermined values obviously being of free choice dependant on how accurate the model is desired to be. This measure prevents unnecessary calculation procedures for equations with combinations of equation-parameters that are correlated or where the introduction of a new equation-parameter does not help predicting the response.

According to a third rule, not only the best performing influencing-parameters at each step are considered to be introduced as equation-parameters, but all possibilities of introduction of influencing-parameters that satisfy the above second rule are considered and sampled. This is a particular advantage of this method, since it has been shown that only combining the best performing influencing-parameters at each stage does not lead to the best model. This includes that after an equation on the basis of the best performing influencing-parameter has been sampled, further equations are successively sampled based on the respective selection of the remaining influencing-parameters that meet the criteria of the above second rule.

The performance of the sampled equation is calculated using standard statistical methods, ie. by calculating and recording values for the whole equation for R², RMSE, max. Prob., max. VIF, F-ratio, Prob>F, SE of the model and SE to the fit. The performance of each sampled equation is recorded in a performance-database with reference to the combination of equation-parameters that was used to obtain this performance. This allows the best performing equation to be selected after having sampled all equations that are possible according to the above rules.

Though the model-method according to the invention is described with reference to modelling life of a piece of equipment of an industrial plant, more particular to modelling coil life in a furnace, it is to be understood that this method provides good results for every variable that is to be predicted in any process using sets of values in databases. Accordingly, mention of a piece of equipment in a furnace is to be understood as representative for every variable in any process. The method according to the invention is thus not to be understood to be limited to uses in furnaces, but to be understood to be applicable in modelling any other variable, too.

The invention has been tried with good results for predicting the life of a piece of equipment in a furnace, especially for coil life and is advantageously used for this.

5

For cases where each influencing-parameter has a high level of significance and a low correlation, it is advantageous to start with an equation generated by multiple regression analysis that is based on all influencing-parameters and to exclude certain parameters from this equation according to specific rule. This can be done according to the following steps:

10

a) generating a current equation based on the all influencing-parameters and as further influencing-parameter a determined start-value as equation-parameters by means of multiple regression analysis based on the values of the value-database,

15

b) determining a significance value and a correlation value for each influencing-parameter with respect to the equation-parameters,

c) selecting as new unnecessary influencing-parameter the equation-parameter with the lowest significance and the highest correlation that is according to a parameter-database not an unnecessary influencing-parameter and whose removal as equation-parameter does according to a parameter-database not lead to a combination of equation-parameters that according to the parameter-database has previously been used ,

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d) replacing the current equation with a new current equation by generating the new current equation based on the set of equation-parameters from which the new unnecessary influencing-parameter has been removed by

means of multiple regression analysis based on the values of the value-database,

5 e) recording in the parameter-database the combinations of parameters used and the order of removal of unnecessary influencing-parameters from the current equation,

10 f) calculating the performance of the current equation and recording this performance with reference to the equation-parameters in the current equation in a performance-database,

15 g) repeating the steps b) to f) until for none of the influencing-parameters that are equation-parameters either the significance is lower than a predetermined value or the correlation is higher than a predetermined value or for one of the unnecessary-parameters the significance has become higher than a predetermined value while at the same time the correlation has become lower than a predetermined value.

20 h) re-introducing the influencing-parameter that according to the parameter-database was last removed as new unnecessary influencing-parameter,

25 i) repeating the steps b) to h) until either the influencing-parameter to be excluded is the start value or until no equation-parameter that has a significance that is lower than a predetermined value or a correlation that is higher than a predetermined value can be excluded without leading to a combination of equation-parameters that has already been sampled,

j) selecting from the database the set of equation-parameters which provided the best performance and generating a final equation by use of multiple

regression analysis based on these influencing-parameters and their individual values in the value-database.

5 In this alternative, when it is determined, whether the significance is lower than a predetermined value and significance is measured by the Prob>F value, it is obvious to the man skilled in the art, that the determination if an influencing-parameter is insignificant is determined by testing whether Prob>F is larger than a predetermined value.

10 For determining the coil life of a coil in a furnace, the variables influencing the coil life are mainly variables that reflect the operating conditions and the design of the furnace.

15 Operating conditions are for example the coil installation date, the quantities of products fed through the furnace and the coil, temperatures in the furnace and on the outside, the kind of products feed through the furnace, inspection results, for example on coil deformation, coil wall thickness and/or coil diameter, rates and ratios of mechanical cleaning, cool down and start up of the furnace.

20 Furnace design variables are for example the site location, feed pipe layout, furnace type, furnace placement, coil placement, coil type, coil material and coil manufacturer. Other pieces of information that can have an influence on coil lifetime and that can be quantified nominally or continuously can additionally be introduced. For modelling coil life in a furnace of a chemical process, especially in ethylene production, operating conditions can among others be described by the quantities of dilution steam, fuel gas and feed; the temperatures of the coil skin, the transfer line exchanger, the coil outlet, the crossover and the stack; the kind of the feed, the quality of the feed (with

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respect to contaminants), the flow of the feed (with respect to amount and fluctuations); the rates and ratios of mechanical cleaning, decoke stops, air/steam ratio during decoke, feed switches, cool down and start up; inspection results on carburisation, coil deformation, coil diameter, coil wall thickness; and design parameters.

Since the model will be used for predicting life of a piece of equipment in a furnace in a continuous process, in which the values of the influencing-parameters might change during operation, the influencing-parameters can be defined as mean values of the parameters and an extra variable per parameter can be introduced as representation of how the parameter has changed during coil life, possibly by use of ratios.

In a preferred embodiment of the method for determining the probable life of a piece of equipment in a furnace, a formula of the type described above under (1) is put together, expressing the expected life in terms of variables relevant for the life and factors of influence, which are the constants. For modelling, influencing-parameters (variables) that are relevant for the life of the piece of equipment are identified, advantageously by use of statistical methods, ie. by determining the significance and the correlation of the variables. Then the data for the variables is collected from already completed processes, ie. processes where the piece of equipment has already failed. Hereafter, a further step can be advantageously added, in order to determine the relevance of the influencing-parameters for which the data has been collected, advantageously by use of statistical methods. This data collection includes data on the actual life achieved in the completed process and the replacement reason. The more data can be collected for each individual process, the more precise the model will become. Also will the accuracy of the model be increased, the larger the number of data sets is, ie. the larger

the number of completed processes that are researched is. A multiple regression analysis will be performed on these data sets in order to generate the constants (factors of influence). Finally these factors of influence can be put into the formula (1) and thus provide a model for coil life. For a newly
5 installed coil or a coil already in operation, values for the influencing parameters can be fed into the equation, which will then give a value of an expected coil life. Furthermore, if a certain life is desired, the method for determining the probable life can be used to establish operating conditions under which the furnace has to be operated in order to achieve the desired
10 life.

Preferably the data is taken from a furnace control system and/or the operational history of a furnace and/or the design of the furnace. Especially using a furnace control system as source for data makes modelling of the life of the
15 piece of equipment simple, as the furnace control system generally stores the data in electronic form, which can easily be used in the multiple regression analysis and which can also easily be used to be fed into the model equation, once this has been derived.

20 Large benefits through minimisation of costs are achieved in plants with furnaces, if the above model is integrated into a method for performing maintenance on the furnace. Due to the increased accuracy of the predicted life of the piece of equipment, purchase of a replacement-piece and cool down of the furnace for replacement can precisely be planned. This makes storing
25 extra pieces obsolete, thus reducing the amount of capital bound by unused equipment. Furthermore, the furnace downtimes and the maintenance frequency can be decreased, as well as the production continuity can be increased.

The method for performing maintenance on a furnace can consist of a system, into which operational data and/or design data of the furnace is fed and which generates a value for an expected life. When the actual life equates to the predicted life, the method for performing maintenance requires a change
5 of the coil. Alternatively, values that are derived from the predicted life can be used. For example, replacement of the coil can take place a week before the actual life equals the predicted life.

10 The operational data fed into the system can be taken from a furnace control system and used to fill the variables in a formula of the type (1) which is stored in the system and which has previously been found by multiple regression analysis in the way described above.

15 The method for performing maintenance can be further improved, if it is designed to be self-learning. That is, if the method allows for modification of the formula used to calculate the expected life. Preferably, collected data for variables relevant for the life of a piece of equipment from a furnace which failed pre-predicted is used to modify the factors of influence. If the piece, on
20 which the method for performing maintenance has been applied, fails before the predicted of life, the data that has been collected for the influencing-parameters over the coil life should be used to modify the factors of influence in order to adapt the formula better to the furnace and the actual running conditions. Especially in a big plant, where the method for performing maintenance is used for a multitude of furnaces, this way of adapting the formula
25 to the actual conditions of the plant will constantly improve the method. One way of improving to modify the factors of influence is to run a new multiple regression analysis in the system, using stored data from completed processes that is supplemented by the new data. Instead of waiting for the coil to fail and to modify the factors of influence only after the coil has failed, modifi-

cation of the factors of influence can also occur pre-failure. The fact that with a coil in operation, operation parameters which the coil has already been subjected to have not caused a failure is important knowledge that can be fed into the multiple regression analysis to improve the accuracy of the model.

According to an aspect of the invention, a maintenance-system is provided that consists of a calculating unit, a storage unit, an input unit, whereby

- 10 - a formula of the type used in multiple regression analysis that expresses an expected life of a piece of equipment in a furnace in terms of influencing-parameters relevant for the life and factors of influence is stored in the storage unit,
- the calculating unit is adapted to read the formula from the storage unit,
- 15 - the calculating unit is adapted to apply the formula to values for the variables received from the input unit and/or read from the storage unit so as to generate a value for an expected life.

20 Such a maintenance-system can be used easily and has the further technical advantage that operational parameters that are generated in a furnace control system, that runs electronically and stores data electronically can easily be read into the system via an input unit that runs electronically allowing for an online, continuous calculation of the expected life.

25

Additionally the calculating unit can be adapted to compare the value for an expected life with a value for the actual life generated from data received from the input unit and/or read from the storage unit to generate a value for remaining life. The value for remaining life gives a figure that is easy to han-

dle when planning the replacement of the piece in use. Also prediction confidence limits, the survival and failure probability and an estimate for the future replacement costs can be generated.

- 5 The method for modelling coil life in a furnace, the method for performing maintenance on a coil in a furnace and the maintenance-system according to the invention can advantageously be used in ethylene production processes and plants. Since ethylene is one of the most produced chemicals, sufficient historical data on coil life for this production process is available, which
10 allows for generating a very accurate model.

An embodiment of the present invention will now be described, by way of an example, with reference to the accompanying drawings, in which:

- 15 Fig. 1 is a representation of the way influencing-parameters are introduced into the equation in order to obtain the combination of influencing-parameters giving the best prediction;
Fig. 2 to 14 are print-outs of results showing the significance and correlation of each influencing-parameter in relation to the influencing-parameters in the
20 equation and showing the performance of the current equation.

The example shown by use of the figures is used to exemplify how the method for determining the probable life of a piece of equipment in a furnace according to the invention is applied. By means of the method according to
25 the invention, the probable coil life of a coil in a furnace is determined.

As influencing-parameters relevant for the coil-life, % Butane tn, % Co-crack tn, % GasCond. tn, % LPG tn and % Naphtha tn are selected. They represent what percentage of the total feed applied to a coil was of the different

types: butane (% Butane), a mixture of regular feed (e.g. Naphtha, LPG) and returned/recycled off-grad product, suitable to be cracked again (% Co-Crack), condensated gas taht is obtained with the extraction of petroleum (% GasCond), liquefied petroleum gas (% LPG) and Naphtha (% Naptha). For
5 these variables, data is collected in a value-database. Here individual values for the coil life (ie. the value when the coil failed (cracked)/is exchanged) are related to the respective individual values of the influencing-parameters that led to the individual coil life.

10 In order to determine the probable coil life, a multiple regression analysis is performed on the collected data. However, the multiple regression analysis is not performed on all influencing-parameters, but tried on several combinations of influencing-parameters in order to obtain the best model.

15 For the following, the influencing-parameters are referred to by numbers, influencing-parameter 1 being % Butane tn, influencing-parameter 2 being % Co-crack tn, influencing-parameter 3 being % GasCond. tn, influencing-parameter 4 being % LPG tn and influencing-parameter 5 being % Naphtha tn.

20 As shown in Fig. 1, starting from the intercept, ie. the mean value of all coil lifes in the database, as start value that is entered as first influencing-parameter into the equation, different influencing-parameters are entered into the equation in order to sample the performance of that equation. Intro-
25 ducing a parameter into the equation is to be understood as adding this new influencing-parameter to the combination of equation-parameters and generating a new current equation on the basis of these equation-parameters, ie. the combination of influencing-parameters that now includes the newly introduced influencing-parameters. Each equation is generated by means of

standard multiple regression analysis, generating a formula, wherein the equation-parameters are variables to the equation and the factors of influence the constants of each equation-parameter. Furthermore, a current equation is generated after removal of an influencing-parameter according to the method.

The introduction of the influencing-parameters or there exclusion respectively is done according to the following steps:

- 1) determining a significance value and a correlation value for each influencing-parameter with respect to the equation-parameter(s),
- 2) selecting as new equation-parameter the influencing-parameter with the highest significance and the lowest correlation that is not an equation-parameter and has according to a parameter-database not been used as equation-parameter in combination with the equation-parameters of the current equation,
- 3) replacing the current equation with a new current equation by generating the new current equation based on the equation-parameters now including the new equation-parameter by means of multiple regression analysis based on the values of the value-database,
- 4) recording in parameter-database the combination of influencing-parameters already used as equation-parameters and the order of introducing the equation-parameters into the current equation,
- 5) calculating the performance of the current equation and recording this performance with reference to the equation-parameters in the current equation in a performance-database
- 6) repeating the steps 1) to 5) until for none of the influencing-parameters that are not equation-parameters the significance is higher than a predetermined value while at the same time the correlation is lower than a predetermined value or either the significance of an equation-parameter has become

lower than a predetermined value or the correlation of an equation-parameter becomes higher than a predetermined value,

7) excluding the influencing-parameter that according to the parameter-database was last selected as new equation-parameter and replacing the current
5 equation with a new current equation by generating the new current equation based on the equation-parameters that remain after exclusion of the last selected influencing-parameter by means of multiple regression analysis based on the values of the value-database,

8) repeating the steps 1) to 7) until the influencing-parameter to be excluded
10 is the start value.

This leads to a series of tried combinations as shown in Fig. 1. Starting from the intercept a significance value ($\text{Prob}>F$) and a correlation value (VIF) for each influencing-parameter with respect to the only equation-parameter (the
15 intercept) is calculated. The result is shown in Fig. 2. This shows that influencing-parameter 1 has the highest significance ($\text{Prob}>F$ has the lowest value) and the lowest correlation (VIF has the lowest value) that satisfy the selected predetermined levels of $\text{Prob}>F$ less than 0,05 and $\text{VIF}<5$. Since
20 influencing-parameter 1 has not been tried as equation-parameter in combination with the intercept, influencing parameter 1 is selected as new equation-parameter and introduced into the equation and the new current equation is generated.

Calculating the significance value and the correlation value of the influencing-
25 influencing-parameters in relation to the new combination of equation-parameters (intercept, 1) leads to the results shown in Fig. 3. Here influencing-parameter 3 is selected as new influencing-parameter to be introduced as equation-parameter, as the correlation is the lowest, the significance is the highest and influencing-parameter 3 has not been tried as equation-parameter in

combination with the influencing-parameters already in the equation (intercept, 1). The new current equation is generated.

5 When calculating Prob>F and VIF for the influencing-parameters in relation to the new combination of equation-parameters, no further influencing-parameter can be selected as new equation-parameter, as no influencing-parameter not yet equation-parameter has a Prob>F value lower than 0,05 and a VIF value of lower than 5 (cf. Fig. 4). While normally this would be expected to be the best model, as the values with the lowest correlation and
10 the highest significance have been introduced into the equation, the method according to the invention teaches to continue combining influencing-parameters into equations by first removing the last introduced influencing-parameter (3). This leads to an equation with results as shown in Fig. 3

15 Though influencing-parameter 3 has - as was said above - the lowest correlation value and lowest significance value (ie. highest significance) at this level, according to the method it can not be selected at this stage, as it has already been tried in combination with the current equation-parameters (intercept, 1). Thus according to the method influencing-parameter 5 is
20 selected as new equation-parameter, as it has a significance that is higher than a predetermined value (Prob>F is less than 0,05) and has a correlation that is lower than a predetermined value (VIF<5) and also has not been tried in combination with the current equation-parameters (intercept, 1). With this set of equation-parameters (intercept, 1, 5) a new current equation is gener-
25 ated.

As shown in Fig. 5, only the significance value and the correlation value of influencing-parameter 3 allow its selection as new equation-parameter, as only these are lower than the predetermined values. Thus a new current

equation is generated on the basis of this combination of equation-parameters.

Fig. 6 shows that by introducing influencing-parameter 3 into the equation,
5 the significance value of influencing-parameter 5 became higher than the
predetermined value ($\text{Prob} > F$ equals 0,4142 which is $> 0,05$). Thus influencing-
parameter 5 became insignificant. According to the method, no new
equation-parameter can be selected at this stage, but the last introduced
10 influencing-parameter has to be removed, ie. influencing-parameter 3. Note
that according to the method, not the influencing-parameter that became
insignificant (5), but the last introduced influencing-parameter (3) is excluded.
The situation thus returns to the combination shown in Fig. 5. Here it can be
seen that no other influencing-parameter satisfies the conditions for signifi-
cance and correlation apart from influencing-parameter 3, which can not be
15 selected as it has already been tried in combination with the current equation
parameters (intercept, 1, 5). Thus, according to the method, the last influ-
encing-parameter introduced into the equation that led to this situation is
removed from the equation, ie. influencing parameter 5. This leads to a
situation as shown in Fig. 3. Once again, no influencing-parameter can be
20 selected, that satisfies the conditions for significance and correlation that at
the same time has not been tried as equation-parameter in combination with
the current equation-parameters (intercept, 1). Thus the last influencing-
parameter entered into the equation that led to this situation has to be
removed, ie. influencing-parameter 1. This leads to the situation shown in
25 Fig. 2.

Fig. 2 shows, that apart from influencing-parameter 1, which has already
been tried in combination with the current equation-parameter (intercept),
Influencing-parameters 3, 5 and 4 satisfy the conditions for correlation and

significance. Of these, influencing-parameter 3 has the lowest correlation and highest significance (lowest Prob>F value) and is thus selected as new equation-parameter. The result is shown in Fig. 7.

5 Though here influencing-parameter 1 shows the lowest correlation and highest significance, since the combination of influencing-parameters intercept, 1 and 3 has already been tried as shown in Fig. 4, influencing-parameter 1 can not be selected as new influencing-parameter at this stage. Thus influencing-parameter 4 is selected, as it satisfies the conditions for significance and correlation and at the same time has not been tried as equation-parameter in
10 combination with the current equation-parameters (intercept, 3). A new current equation is generated.

15 Fig. 8 shows the correlation and significance of the influencing-parameters in relation to the equation-parameters (intercept, 3,4). It can be seen that here influencing-parameter 5 can be selected as new equation-parameter as it satisfies the above mentioned conditions and has not been tried in combination with the equation-parameters (intercept, 3, 4). A further current equation is generated.

20 As can be deduced from Fig. 9, no new equation-parameter can be selected, as none of the influencing-parameters that are not equation-parameters satisfies the conditions. Thus according to the method, the last introduced influencing-parameter is removed from the equation, ie. influencing-parameter 5. This leads to a situation as shown in Fig. 8.
25

Since influencing-parameter 5 can now not be selected, as it has already been tried in combination with the current equation-parameters (intercept, 3,4), only influencing-parameter 1 can be selected, as it satisfies the above

mentioned conditions, ie. has a correlation value that is lower than the pre-determined value ($VIF < 5$) and a significance value that is lower than a pre-determined value ($Prob > F$ is less than 0,05). With the selected influencing-parameter 1 a new current equation is generated.

5

As shown in Fig. 10, the introduction of influencing-parameter 1 causes influencing-parameter 4 (an equation-parameter) to become insignificant. According to the method, no further influencing-parameter is selected as equation-parameter, but the last introduced influencing-parameter (1) is removed. This leads to the same situation as shown in Fig. 8. Here it can be seen that no other influencing-parameter satisfies the conditions for significance and correlation apart from influencing-parameter 5, which can not be selected as it has already been tried in combination with the current equation-parameters (intercept, 3, 4). Thus, according to the method, the last influencing-parameter introduced into the equation that led to this situation is removed from the equation, ie. influencing parameter 4. This leads to a situation as shown in Fig. 7. Once again, no influencing-parameter can be selected, that satisfies the conditions for significance and correlation that at the same time has not been tried as equation-parameter in combination with the current-equation parameters (intercept, 3). Thus the last influencing-parameter entered into the equation that led to this situation has to be removed, ie. influencing-parameter 3. This leads to the situation shown in Fig. 2.

25 Fig. 2 shows, that apart from influencing-parameters 1,3, which have already been tried in combination with the current equation-parameter (intercept), influencing-parameters 5 and 4 satisfy the conditions for correlation and significance. Of these, influencing-parameter 5 has the lowest correlation and

highest significance (lowest Prob>F value) and is thus selected as new equation-parameter. The result is shown in Fig. 11.

5 As influencing-parameter 1 has already been tried in combination with the current equation parameters (intercept, 5) as seen in Fig. 5, only influencing-parameter 3 remains that can be selected as new equation-parameter according to the above conditions. The new current equation generated on the basis of this combination of influencing parameters (intercept, 5,3) leads to a situation as shown in Fig. 12.

10

There it can be seen that by introducing influencing-parameter 3 into the equation, influencing-parameter 5 (an equation-parameter) has been made insignificant. Thus according to the method the last introduced influencing-parameter is removed (influencing-parameter 3), which leads to a situation shown in Fig. 11 from which no further influencing-parameter can be removed. Accordingly, the last introduced influencing-parameter, that led to this situation, is removed (influencing-parameter 5), which leads to a situation shown in Fig. 2.

15

20 Fig. 2 shows, that apart from influencing-parameters 1,3,5, which have already been tried in combination with the current equation-parameter (intercept), influencing-parameter 4 satisfies the conditions for correlation and significance. Thus this is selected as new equation-parameter. The result is shown in Fig. 13.

25

As influencing-parameter 3 has already been tried in combination with the current equation parameters (intercept, 4) as seen in Fig. 8, only influencing-parameter 1 remains that can be selected as new equation-parameter according to the above conditions. The new current equation generated on

the basis of this combination of influencing parameters (intercept, 4,1) leads to a situation as shown in Fig. 14.

5 There it can be seen that by introducing influencing-parameter 3 into the equation, influencing-parameter 4 (an equation-parameter) has been made insignificant. Thus according to the method the last introduced influencing-parameter is removed (influencing-parameter 1), which leads to a situation shown in Fig. 13 from which no further influencing-parameter can be removed. Accordingly, the last introduced influencing-parameter, that led to
10 this situation, is removed (influencing-parameter 5), which leads to a situation shown in Fig. 2. From here, no other influencing-parameter can be selected as new equation-parameter, which according to the method would lead to the last entered influencing-parameter to be removed. Since this is however the start-value (intercept) the process of introducing/removing influencing-parameters is halted at this stage.
15

Now the equation that provided the best performance needs to be selected. During each calculation step for a new current equation, the performance of the current equation was calculated and is represented in the respective
20 Figs. These performance-values in relation to the combination of influencing-parameters in the equation that led to this performance are stored at each step in a performance-database. From this database the combination of influencing-parameters leading to the best performing equation (influencing-parameters 3,4,5 as can be seen from Fig. 9) is selected and the final equation
25 is generated.

Current values taken from the operating furnace are fed into this equation, which then leads to a value for the probable coil life.

In order to aid determining which influencing-parameter can be added or which influencing-parameter has to be removed as last introduced influencing-parameter, at each step a parameter-database keeps record of what combinations have already been tried and in what order the influencing-parameters were introduced into the equation.

From this example it can be seen that the method according to the invention leads to a result, that would previously not be expected. Instead of only introducing strong influencing-parameters into the equation, ie. those that have a very low correlation and a very high significance, according to the method also less strong variables are tried. Traditionally, the model as shown in Fig. 4 would be considered as best model. However comparing the performances shows, that the combination of Fig. 9 leads to the best performing model.

The method according to the invention not only leads to a better model, but also reduces calculation time and hardware necessary to obtain this better model. According to the method, not all possible combinations of influencing-parameters as equation-parameters have to be tried, which would lead to immense calculation times and would make fast calculating machines necessary, but only a special selection of combinations is tried.

Patent Claims:

- 5 1. Method for determining the probable life of a piece of equipment in an industrial plant which uses multiple regression analysis to express an expected life in terms of variables relevant for the life.
2. Method according to claim 1, consisting at least of the following steps:
 - 10 - identifying the variables relevant for the life of the piece of equipment,
 - collecting data for the variables relevant for the life of the piece of equipment and the according life,
 - 15 - performing a multiple regression analysis using the collected data to determine for the variables factors of influence on the life,
 - generating a formula of the type used in multiple regression analysis, expressing the expected life in terms of the variables using the factors of influence found.
- 20 3. Method according to claim 2, wherein the data is taken from a control system and/or the operational history of an industrial plant and/or the design of the industrial plant.
- 25 4. Method according to one of the claims 1 to 3, whereby a formula to model the expected life from a value-database correlating individual values for the life with other individual values of one or more influencing-parameters, contains the following steps:
 - a) determining a start value as first influencing-parameter,

b) generating a current equation based on the start value and thereby entering the start value as equation-parameter into the equation,

5 c) determining a significance value and a correlation value for each influencing-parameter with respect to the equation-parameter(s),

10 d) selecting as new equation-parameter the influencing-parameter with the highest significance and the lowest correlation that is not an equation-parameter and has according to a parameter-database not been used as equation-parameter in combination with the equation-parameters of the current equation,

15 e) replacing the current equation with a new current equation by generating the new current equation based on the equation-parameters now including the new equation-parameter by means of multiple regression analysis based on the values of the value-database,

20 f) recording in parameter-database the combination of influencing-parameters already used as equation-parameters and the order of introducing the equation-parameters into the current equation,

25 g) calculating the performance of the current equation and recording this performance with reference to the equation-parameters in the current equation in a performance-database

h) repeating the steps c) to g) until for none of the influencing-parameters that are not equation-parameters the significance is higher than a predetermined value while at the same time the correlation is lower

than a predetermined value or either the significance of an equation-parameter has become lower than a predetermined value or the correlation of an equation-parameter becomes higher than a predetermined value,

5

i) excluding the influencing-parameter that according to the parameter-database was last selected as new equation-parameter and replacing the current equation with a new current equation by generating the new current equation based on the equation-parameters that remain after exclusion of the last selected influencing-parameter by means of multiple regression analysis based on the values of the value-database,

10

j) repeating the steps c) to i) until the influencing-parameter to be excluded is the start value,

15

k) selecting from the database the set of equation-parameters which provided the best performance and generating a final equation by use of multiple regression analysis based on these influencing-parameters and their individual values in the value-database.

20

5. Method according to one of the claims 1 to 3, whereby a formula to model the expected life from a value-database correlating individual values for the life with other individual values of one or more influencing-parameters, contains the following steps:

25

a) generating a current equation based on the all influencing-parameters and as further influencing-parameter a determined start-value as equation-parameters by means of multiple regression analysis based on the values of the value-database,

b) determining a significance value and a correlation value for each influencing-parameter with respect to the equation-parameters,

5 c) selecting as new unnecessary influencing-parameter the equation-parameter with the lowest significance and the highest correlation that is according to a parameter-database not an unnecessary influencing-parameter and whose removal as equation-parameter does according to a parameter-database not lead to a combination of equation-parameters that according to the parameter-database has previously
10 been used ,

d) replacing the current equation with a new current equation by generating the new current equation based on the set of equation-parameters from which the new unnecessary influencing-parameter has been removed by means of multiple regression analysis based on the values
15 of the value-database,

e) recording in the parameter-database the combinations of parameters used and the order of removal of unnecessary influencing-parameters from the current equation,
20

f) calculating the performance of the current equation and recording this performance with reference to the equation-parameters in the current equation in a performance-database,
25

g) repeating the steps b) to f) until for none of the influencing-parameters that are equation-parameters either the significance is lower than a predetermined value or the correlation is higher than a predetermined value or for one of the unnecessary-parameters the significance has

become higher than a predetermined value while at the same time the correlation has become lower than a predetermined value.

5 h) re-introducing the influencing-parameter that according to the parameter-database was last removed as new unnecessary influencing-parameter,

10 i) repeating the steps b) to h) until either the influencing-parameter to be excluded is the start value or until no equation-parameter that has a significance that is lower than a predetermined value or a correlation that is higher than a predetermined value can be excluded without leading to a combination of equation-parameters that has already been sampled,

15 j) selecting from the database the set of equation-parameters which provided the best performance and generating a final equation by use of multiple regression analysis based on these influencing-parameters and their individual values in the value-database.

20

25 6. Method for performing maintenance on an industrial plant, whereby operational data and/or design data of the industrial plant is fed into a system, which generates at least one value for an expected life of one piece of equipment of the industrial plant and whereby the piece of equipment is exchanged when the actual life equates to the predicted life or a value derived from the predicted life, whereby

- the system uses a formula of the type used in multiple regression analysis, expressing the expected life in terms of variables relevant for the life using factors of influence and
- the factors of influence are found by performing a multiple regression analysis using data collected for variables relevant for the life and the according life.

7. Method according to claim 6, characterised in that collected data for variables relevant for the life from a piece of equipment of the same type which failed pre-predicted is used to modify the factors of influence.

8. Method according to claim 6 or 7, characterised in that a method according to one of the claims 1 to 5 is used.

9. Maintenance-System consisting of a calculating unit, a storage unit, an input unit characterised in that

- a formula of the type used in multiple regression analysis that expresses an expected life of a piece of equipment in terms of influencing-parameters relevant for the life and factors of influence is stored in the storage unit,
- the calculating unit is adapted to read the formula from the storage unit,
- the calculating unit is adapted to apply the formula to values for the variables received from the input unit and/or read from the storage unit so as to generate a value for an expected life.

10. Maintenance-System according to claim 9, characterised in that the calculating unit is adapted to compare the value for an expected life with a value for the actual life generated from data received from the input unit and/or read from the storage unit to generate a value for remaining life.
11. Use of the method according to one of the claims 1 to 5, of the method according to claim 6 to 8 and/or of the maintenance-system according to claim 9 or 10 for operating an ethylene production plant.

August 28, 2002
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Abstract:

Method for determining the probable life of a piece of equipment in an industrial plant which uses multiple regression analysis to express an expected life in terms of variables relevant for the life. And Method for performing maintenance on an industrial plant, whereby operational data and/or design data of the industrial plant is fed into a system, which generates at least one value for an expected life of one piece of equipment of the industrial plant and whereby the piece of equipment is exchanged when the actual life equates to the predicted life or a value derived from the predicted life, whereby

- 5
- 10
- the system uses a formula of the type used in multiple regression analysis, expressing the expected life in terms of variables relevant for the life using factors of influence and
 - the factors of influence are found by performing a multiple regression analysis using data collected for variables relevant for the life and the according life.
- 15

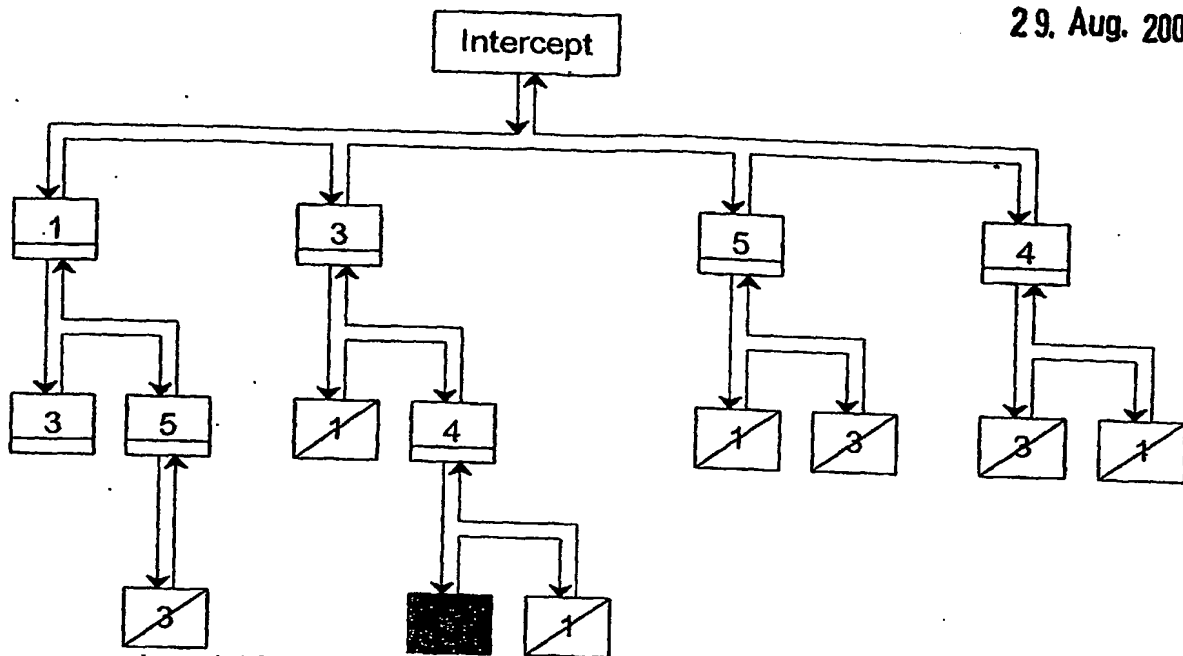


Fig. 1

[illegible]

Fig. 2

Variable	Parameter	Initial Value	Estimate	Standard Error	F Ratio	Prob > F	Model Performance
1	Intercept	1	17.22	3.81	0.0001	0.00	Model criteria
2	Age	1	0.00	2.00	0.0000	0.00	Model criteria
3	Gender	1	0.00	1.00	0.0000	0.00	Model criteria
4	Education	1	0.00	0.00	0.0000	0.00	Model criteria
5	Occupation	1	0.00	0.00	0.0000	0.00	Model criteria
6	Marital Status	1	0.00	0.00	0.0000	0.00	Model criteria

Fig. 3

Variable	Parameter	Initial Value	Estimate	Standard Error	F Ratio	Prob > F	Model Performance
1	Intercept	1	17.22	3.81	0.0001	0.00	Model criteria
2	Age	1	0.00	2.00	0.0000	0.00	Model criteria
3	Gender	1	0.00	1.00	0.0000	0.00	Model criteria
4	Education	1	0.00	0.00	0.0000	0.00	Model criteria
5	Occupation	1	0.00	0.00	0.0000	0.00	Model criteria
6	Marital Status	1	0.00	0.00	0.0000	0.00	Model criteria

Fig. 4

Variable	Parameter	Initial Value	Estimate	Standard Error	F Ratio	Prob > F	Model Performance
1	Intercept	1	17.22	3.81	0.0001	0.00	Model criteria
2	Age	1	0.00	2.00	0.0000	0.00	Model criteria
3	Gender	1	0.00	1.00	0.0000	0.00	Model criteria
4	Education	1	0.00	0.00	0.0000	0.00	Model criteria
5	Occupation	1	0.00	0.00	0.0000	0.00	Model criteria
6	Marital Status	1	0.00	0.00	0.0000	0.00	Model criteria

Fig. 5

Variable	Parameter	Initial Value	Estimate	Standard Error	F Ratio	Prob > F	Model Performance
1	Intercept	1	17.22	3.81	0.0001	0.00	Model criteria
2	Age	1	0.00	2.00	0.0000	0.00	Model criteria
3	Gender	1	0.00	1.00	0.0000	0.00	Model criteria
4	Education	1	0.00	0.00	0.0000	0.00	Model criteria
5	Occupation	1	0.00	0.00	0.0000	0.00	Model criteria
6	Marital Status	1	0.00	0.00	0.0000	0.00	Model criteria

Fig. 6

Value	Parameter	Input	Estimate	Ratio	Prob	VF	Model performance
0.0000	Intercept	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000

Fig. 7

Value	Parameter	Input	Estimate	Ratio	Prob	VF	Model performance
0.0000	Intercept	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000

Fig. 8

Value	Parameter	Input	Estimate	Ratio	Prob	VF	Model performance
0.0000	Intercept	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000

Fig. 9

Value	Parameter	Input	Estimate	Ratio	Prob	VF	Model performance
0.0000	Intercept	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000
0.0000	Parameter	1.0000	0.0000	0.0000	0.0000	0.0000	0.0000

Fig. 10

[illegible]

Fig. 11

[illegible]

Fig. 12

Year	Model	Performance	Price	Availability
1990	Model A	100	1000	Available
1991	Model B	120	1200	Available
1992	Model C	150	1500	Available
1993	Model D	180	1800	Available
1994	Model E	200	2000	Available
1995	Model F	220	2200	Available
1996	Model G	250	2500	Available
1997	Model H	280	2800	Available
1998	Model I	300	3000	Available
1999	Model J	320	3200	Available
2000	Model K	350	3500	Available
2001	Model L	380	3800	Available
2002	Model M	400	4000	Available
2003	Model N	420	4200	Available
2004	Model O	450	4500	Available
2005	Model P	480	4800	Available
2006	Model Q	500	5000	Available
2007	Model R	520	5200	Available
2008	Model S	550	5500	Available
2009	Model T	580	5800	Available
2010	Model U	600	6000	Available
2011	Model V	620	6200	Available
2012	Model W	650	6500	Available
2013	Model X	680	6800	Available
2014	Model Y	700	7000	Available
2015	Model Z	720	7200	Available
2016	Model AA	750	7500	Available
2017	Model AB	780	7800	Available
2018	Model AC	800	8000	Available
2019	Model AD	820	8200	Available
2020	Model AE	850	8500	Available
2021	Model AF	880	8800	Available
2022	Model AG	900	9000	Available
2023	Model AH	920	9200	Available
2024	Model AI	950	9500	Available
2025	Model AJ	980	9800	Available
2026	Model AK	1000	10000	Available
2027	Model AL	1020	10200	Available
2028	Model AM	1050	10500	Available
2029	Model AN	1080	10800	Available
2030	Model AO	1100	11000	Available
2031	Model AP	1120	11200	Available
2032	Model AQ	1150	11500	Available
2033	Model AR	1180	11800	Available
2034	Model AS	1200	12000	Available
2035	Model AT	1220	12200	Available
2036	Model AU	1250	12500	Available
2037	Model AV	1280	12800	Available
2038	Model AW	1300	13000	Available
2039	Model AX	1320	13200	Available
2040	Model AY	1350	13500	Available
2041	Model AZ	1380	13800	Available
2042	Model BA	1400	14000	Available
2043	Model BB	1420	14200	Available
2044	Model BC	1450	14500	Available
2045	Model BD	1480	14800	Available
2046	Model BE	1500	15000	Available
2047	Model BF	1520	15200	Available
2048	Model BG	1550	15500	Available
2049	Model BH	1580	15800	Available
2050	Model BI	1600	16000	Available
2051	Model BJ	1620	16200	Available
2052	Model BK	1650	16500	Available
2053	Model BL	1680	16800	Available
2054	Model BM	1700	17000	Available
2055	Model BN	1720	17200	Available
2056	Model BO	1750	17500	Available
2057	Model BP	1780	17800	Available
2058	Model BQ	1800	18000	Available
2059	Model BR	1820	18200	Available
2060	Model BS	1850	18500	Available
2061	Model BT	1880	18800	Available
2062	Model BU	1900	19000	Available
2063	Model BV	1920	19200	Available
2064	Model BW	1950	19500	Available
2065	Model BX	1980	19800	Available
2066	Model BY	2000	20000	Available
2067	Model BZ	2020	20200	Available
2068	Model CA	2050	20500	Available
2069	Model CB	2080	20800	Available
2070	Model CC	2100	21000	Available
2071	Model CD	2120	21200	Available
2072	Model CE	2150	21500	Available
2073	Model CF	2180	21800	Available
2074	Model CG	2200	22000	Available
2075	Model CH	2220	22200	Available
2076	Model CI	2250	22500	Available
2077	Model CJ	2280	22800	Available
2078	Model CK	2300	23000	Available
2079	Model CL	2320	23200	Available
2080	Model CM	2350	23500	Available
2081	Model CN	2380	23800	Available
2082	Model CO	2400	24000	Available
2083	Model CP	2420	24200	Available
2084	Model CQ	2450	24500	Available
2085	Model CR	2480	24800	Available
2086	Model CS	2500	25000	Available
2087	Model CT	2520	25200	Available
2088	Model CU	2550	25500	Available
2089	Model CV	2580	25800	Available
2090	Model CW	2600	26000	Available
2091	Model CX	2620	26200	Available
2092	Model CY	2650	26500	Available
2093	Model CZ	2680	26800	Available
2094	Model DA	2700	27000	Available
2095	Model DB	2720	27200	Available
2096	Model DC	2750	27500	Available
2097	Model DD	2780	27800	Available
2098	Model DE	2800	28000	Available
2099	Model DF	2820	28200	Available
2100	Model DG	2850	28500	Available
2101	Model DH	2880	28800	Available
2102	Model DI	2900	29000	Available
2103	Model DJ	2920	29200	Available
2104	Model DK	2950	29500	Available
2105	Model DL	2980	29800	Available
2106	Model DM	3000	30000	Available
2107	Model DN	3020	30200	Available
2108	Model DO	3050	30500	Available
2109	Model DP	3080	30800	Available
2110	Model DQ	3100	31000	Available
2111	Model DR	3120	31200	Available
2112	Model DS	3150	31500	Available
2113	Model DT	3180	31800	Available
2114	Model DU	3200	32000	Available
2115	Model DV	3220	32200	Available
2116	Model DW	3250	32500	Available
2117	Model DX	3280	32800	Available
2118	Model DY	3300	33000	Available
2119	Model DZ	3320	33200	Available
2120	Model EA	3350	33500	Available
2121	Model EB	3380	33800	Available
2122	Model EC	3400	34000	Available
2123	Model ED	3420	34200	Available
2124	Model EE	3450	34500	Available
2125	Model EF	3480	34800	Available
2126	Model EG	3500	35000	Available
2127	Model EH	3520	35200	Available
2128	Model EI	3550	35500	Available
2129	Model EJ	3580	35800	Available
2130	Model EK	3600	36000	Available
2131	Model EL	3620	36200	Available
2132	Model EM	3650	36500	Available
2133	Model EN	3680	36800	Available
2134	Model EO	3700	37000	Available
2135	Model EP	3720	37200	Available
2136	Model EQ	3750	37500	Available
2137	Model ER	3780	37800	Available
2138	Model ES	3800	38000	Available
2139	Model ET	3820	38200	Available
2140	Model EU	3850	38500	Available
2141	Model EV	3880	38800	Available
2142	Model EW	3900	39000	Available
2143	Model EX	3920	39200	Available
2144	Model EY	3950	39500	Available
2145	Model EZ	3980	39800	Available
2146	Model FA	4000	40000	Available
2147	Model FB	4020	40200	Available
2148	Model FC	4050	40500	Available
2149	Model FD	4080	40800	Available
2150	Model FE	4100	41000	Available
2151	Model FF	4120	41200	Available
2152	Model FG	4150	41500	Available
2153	Model FH	4180	41800	Available
2154	Model FI	4200	42000	Available
2155	Model FJ	4220	42200	Available
2156	Model FK	4250	42500	Available
2157	Model FL	4280	42800	Available
2158	Model FM	4300	43000	Available
2159	Model FN	4320	43200	Available
2160	Model FO	4350	43500	Available
2161	Model FP	4380	43800	Available
2162	Model FQ	4400	44000	Available
2163	Model FR	4420	44200	Available
2164	Model FS	4450	44500	Available
2165	Model FT	4480	44800	Available
2166	Model FU	4500	45000	Available
2167	Model FV	4520	45200	Available
2168	Model FW	4550	45500	Available
2169	Model FX	4580	45800	Available
2170	Model FY	4600	46000	Available
2171	Model FZ	4620	46200	Available
2172	Model GA	4650	46500	Available
2173	Model GB	4680	46800	Available
2174	Model GC	4700	47000	Available
2175	Model GD	4720	47200	Available
2176	Model GE	4750	47500	Available
2177	Model GF	4780	47800	Available
2178	Model GH	4800	48000	Available
2179	Model GI	4820	48200	Available
2180	Model GJ	4850	48500	Available
2181	Model GK	4880	48800	Available
2182	Model GL	4900	49000	Available
2183	Model GM	4920	49200	Available
2184	Model GN	4950	49500	Available
2185	Model GO	4980	49800	Available
2186	Model GP	5000	50000	Available
2187	Model GQ	5020	50200	Available
2188	Model GR	5050	50500	Available
2189	Model GS	5080	50800	Available
2190	Model GT	5100	51000	Available
2191	Model GU	5120	51200	Available
2192	Model GV	5150	51500	Available
2193	Model GW	5180	51800	Available
2194	Model GX	5200	52000	Available
2195	Model GY	5220	52200	Available
2196	Model GZ	5250	52500	Available
2197	Model HA	5280	52800	Available
2198	Model HB	5300	53000	Available
2199	Model HC	5320	53200	Available
2200	Model HD	5350	53500	Available
2201	Model HE	5380	53800	Available
2202	Model HF	5400	54000	Available
2203	Model HG	5420	54200	Available
2204	Model HH	5450	54500	Available
2205	Model HI	5480	54800	Available
2206	Model HJ	5500	55000	Available
2207	Model HK	5520	55200	Available
2208	Model HL	5550	55500	Available
2209	Model HM	5580	55800	Available
2210	Model HN	5600	56000	Available
2211	Model HO	5620	56200	Available
2212	Model HP	5650	56500	Available
2213	Model HQ	5680	56800	Available
2214	Model HR	5700	57000	Available
2215	Model HS	5720	57200	Available
2216	Model HT	5750	57500	Available
2217	Model HU	5780	57800	Available
2218	Model HV	5800	58000	Available
2219	Model HW	5820	58200	Available
2220	Model HX	5850	58500	Available
2221	Model HY	5880	58800	Available
2222	Model HZ	5900	59000	Available
2223	Model IA	5920	59200	Available
2224	Model IB	5950	59500	Available
2225	Model IC	5980	59800	Available
2226	Model ID	6000	60000	Available
2227	Model IE	6020	60200	Available
2228	Model IF	6050	60500	Available
2229	Model IG	6080	60800	Available
2230	Model IH	6100	61000	Available
2231	Model II	6120	61200	Available
2232	Model IJ	6150	61500	Available
2233	Model IK	6180	61800	Available
2234	Model IL	6200	62000	Available
2235	Model IM	6220	62200	Available
2236	Model IN	6250	62500	Available
2237	Model IO	6280	62800	Available
2238	Model IP	6300	63000	Available
2239	Model IQ	6320	63200	Available
2240	Model IR	6350	63500	Available
2241	Model IS	6380	63800	Available
2242	Model IT	6400	64000	Available
2243	Model IU	6420	64200	Available
2244	Model IV	6450	64500	Available
2245	Model IW	6480	64800	Available
2246	Model IX	6500	65000	Available
2247	Model IY	6520	65200	Available
2248	Model IZ	6550	65500	Available
2249	Model JA	6580	65800	Available
2250	Model JB	6600	66000	Available
2251	Model JC	6620	66200	Available
2252	Model JD	6650	66500	Available
2253	Model JE	6680	66800	Available
2254	Model JF	6700	67000	Available
2255	Model JG	6720	67200	Available
2256	Model JH	6750	67500	Available
2257	Model JI	6780	67800	Available
2258	Model JJ	6800	68000	Available
2259	Model JK	6820	68200	Available
2260	Model JL	6850	68500	Available
2261	Model JM	6880	68800	Available
2262	Model JN	6900	69000	Available
2263	Model JO	6920	69200	Available
2264	Model JP	6950	69500	Available
2265	Model JQ			

Fig. 13

2. Model Performance					
Value	Parameter	Input Data	Estimate	SE	Prob
0.000	Intercept	1	0.000	0.000	0.000
0.000	Age	1	0.000	0.000	0.000
0.000	Gender	1	0.000	0.000	0.000
0.000	Marital Status	1	0.000	0.000	0.000
0.000	Education	1	0.000	0.000	0.000
0.000	Income	1	0.000	0.000	0.000
0.000	Health	1	0.000	0.000	0.000
0.000	Exercise	1	0.000	0.000	0.000
0.000	Stress	1	0.000	0.000	0.000
0.000	Sleep	1	0.000	0.000	0.000
0.000	Diet	1	0.000	0.000	0.000
0.000	Work	1	0.000	0.000	0.000
0.000	Family	1	0.000	0.000	0.000
0.000	Environment	1	0.000	0.000	0.000
0.000	Genetics	1	0.000	0.000	0.000
0.000	History	1	0.000	0.000	0.000
0.000	Current	1	0.000	0.000	0.000
0.000	Future	1	0.000	0.000	0.000
0.000	Past	1	0.000	0.000	0.000
0.000	Present	1	0.000	0.000	0.000
0.000	Unknown	1	0.000	0.000	0.000
0.000	Other	1	0.000	0.000	0.000
0.000	None	1	0.000	0.000	0.000
0.000	All	1	0.000	0.000	0.000
0.000	Some	1	0.000	0.000	0.000
0.000	Most	1	0.000	0.000	0.000
0.000	Very	1	0.000	0.000	0.000
0.000	Extremely	1	0.000	0.000	0.000
0.000	Almost	1	0.000	0.000	0.000
0.000	Nearly	1	0.000	0.000	0.000
0.000	Quite	1	0.000	0.000	0.000
0.000	Fairly	1	0.000	0.000	0.000
0.000	Reasonably	1	0.000	0.000	0.000
0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
0.000	Marginally	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Barely	1	0.000	0.000	0.000
0.000	Hardly	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Almost	1	0.000	0.000	0.000
0.000	Nearly	1	0.000	0.000	0.000
0.000	Quite	1	0.000	0.000	0.000
0.000	Fairly	1	0.000	0.000	0.000
0.000	Reasonably	1	0.000	0.000	0.000
0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
0.000	Marginally	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Barely	1	0.000	0.000	0.000
0.000	Hardly	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Almost	1	0.000	0.000	0.000
0.000	Nearly	1	0.000	0.000	0.000
0.000	Quite	1	0.000	0.000	0.000
0.000	Fairly	1	0.000	0.000	0.000
0.000	Reasonably	1	0.000	0.000	0.000
0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
0.000	Marginally	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Barely	1	0.000	0.000	0.000
0.000	Hardly	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Almost	1	0.000	0.000	0.000
0.000	Nearly	1	0.000	0.000	0.000
0.000	Quite	1	0.000	0.000	0.000
0.000	Fairly	1	0.000	0.000	0.000
0.000	Reasonably	1	0.000	0.000	0.000
0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
0.000	Marginally	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Barely	1	0.000	0.000	0.000
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0.000	Almost	1	0.000	0.000	0.000
0.000	Nearly	1	0.000	0.000	0.000
0.000	Quite	1	0.000	0.000	0.000
0.000	Fairly	1	0.000	0.000	0.000
0.000	Reasonably	1	0.000	0.000	0.000
0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
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0.000	Barely	1	0.000	0.000	0.000
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0.000	Scarcely	1	0.000	0.000	0.000
0.000	Almost	1	0.000	0.000	0.000
0.000	Nearly	1	0.000	0.000	0.000
0.000	Quite	1	0.000	0.000	0.000
0.000	Fairly	1	0.000	0.000	0.000
0.000	Reasonably	1	0.000	0.000	0.000
0.000	Modestly	1	0.000	0.000	0.000
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0.000	Marginally	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Barely	1	0.000	0.000	0.000
0.000	Hardly	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Almost	1	0.000	0.000	0.000
0.000	Nearly	1	0.000	0.000	0.000
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0.000	Reasonably	1	0.000	0.000	0.000
0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
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0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
0.000	Marginally	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Barely	1	0.000	0.000	0.000
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0.000	Scarcely	1	0.000	0.000	0.000
0.000	Almost	1	0.000	0.000	0.000
0.000	Nearly	1	0.000	0.000	0.000
0.000	Quite	1	0.000	0.000	0.000
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0.000	Reasonably	1	0.000	0.000	0.000
0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
0.000	Marginally	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Barely	1	0.000	0.000	0.000
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0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
0.000	Marginally	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Barely	1	0.000	0.000	0.000
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0.000	Slightly	1	0.000	0.000	0.000
0.000	Marginally	1	0.000	0.000	0.000
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0.000	Marginally	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000
0.000	Barely	1	0.000	0.000	0.000
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0.000	Reasonably	1	0.000	0.000	0.000
0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
0.000	Marginally	1	0.000	0.000	0.000
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0.000	Barely	1	0.000	0.000	0.000
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0.000	Reasonably	1	0.000	0.000	0.000
0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
0.000	Marginally	1	0.000	0.000	0.000
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0.000	Reasonably	1	0.000	0.000	0.000
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0.000	Slightly	1	0.000	0.000	0.000
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0.000	Barely	1	0.000	0.000	0.000
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0.000	Reasonably	1	0.000	0.000	0.000
0.000	Modestly	1	0.000	0.000	0.000
0.000	Slightly	1	0.000	0.000	0.000
0.000	Marginally	1	0.000	0.000	0.000
0.000	Scarcely	1	0.000	0.000	0.000

Fig. 14

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